Work Orde August-29-13 1:		06393		*106	3.39	93*							Page 1
Revision ID:	D4097-041  ARMREST A	ASSY	<u> </u>	Accept	*	<b>N</b> 900	<b>040</b>	100	)*	Setup	Start Stop	*N:	S1* S2*
	8/29/13 8/29/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*			Cust Item I Customer:	D:						
Approvals:		an: _MC5					ate:	· 		Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	- <del>-</del>	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr			·			- <del>1-</del>					<del></del>
D4097	Α												
100				0.00					_			Α.	
*100* Small Fab			LO. c as per dwg K Ki†:	0.00					_2x Zx	_	<b>!</b> },	W-13 2 ]	3-09-3 Js/04
110		QC5- Inspect part comp	leteness to step on W/O	0.00									
*110* QC Quality Control		Memo		0.00 27 189 13 9	Ç				<u> </u>		<del></del> -		<del></del>
120		Identify as per dwg & S	tock Location:	0.00					_			<b>99</b> 21	
*120* Packaging		Memo	52708	0.00					$\overset{\mathcal{L}}{\simeq}$				<u>o'</u>

Packaging

											DQA:	Dat	te: _	
NCR:	Yes	/ No				WORK ORDER NON-C	10:	VFORM	MANCE / UP	DATE			_	
								_			QA Closed:	Dat	te:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK OIG	=1-					Rework	1		Skid-tube	Crosstube	1	Water Jet	$\neg$	Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	┪	Quality
	-				<del></del>	Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR I	No.					Work Order Update			Large Fab	Composite	]	Supplier		
											<del>,</del>			
Root	1					ption of work order update	l	nitial	Act		Sign &		-	
Cause	,	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	1	QC Inspector
Doc/Data	Ш										i			
Equip/Tooling	Ш		-			i						!		
Operator	Н							i						
Material	Н			]										
Setup	$\vdash \vdash$		}	]										
Other	Н													
Process	Н		<u> </u>				1							
Supplier Training	Н		j											
Unapproved	Н		İ										- 1	
опарргочес			<u> </u>	<u> </u>		F	AUL	T CATE	GORY		<del>-</del>	<del></del>		*
Landi	ng G	Sear				General								
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	`	Weld
		Crushed/Crimped Burrs					instruct	ions Incomplete/L	Inclear	Part Lost/M	issing	\	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	enance	<u> </u>	Part Moved			
	Heat Treat Countersink					L_	Mislabe	eled		Positioned V				
	Inspection Strip in Tube Cut Too Short							Misread	<b>3</b>		Power Loss/	Surge		Other
	Ripples in Bend Drill Holes						_	Offset						
1	Torque Waves in Extrusion Drawing							Out of 0	Calibration					

Out of Calibration Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord		06393		*106	3393*			. = . = .	·			Page 2	
Item ID: Revision ID: Item Name:	D4097-041 ARMREST			Accept	*N9000	740	100	)*	Setup	Start Stop	171	S1* S2*	
Start Date: Required Date	8/29/13 e: 8/29/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID Customer:	<b>)</b> :							
Reference: Approvals:		lan:		Tooling: SPC (Y/N):	Dat	te:	- 		Run	Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center	1D	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	i Re Qt	•	Reject Number	Insp. Stamp	<b>,+·</b> -

0.00

Memo

\*130\*

Quality Control

13/9/9 A) MF 13-9-19/6

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-	cor	NFORM	MANCE / UPI	DATE					
												QA Closed:	Da	ite:	
Work Orde	٠	-				DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
WORK OTER	۲۱.	· <u> </u>				Rework	7		Skid-tube	Crosstube		]	Water Jet	_	Engineering
Part 1	Vo.					Scrap	┨	•	Machining	Small Fab		Pro	d. Eng. Coor.	-	Quality
	•	-				Use-as-is	1		noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR I	۷o.	_				Work Order Update			Large Fab	Composite		]	Supplier		
Post				Γ	Docari	ption of work order update	Т	Initial	Act	tion		Sign &			
Root Cause		Date	Step	Qty	l .	or Non-conformance	1	nief Eng		ription		Date	Verificatio	n In	QC Inspector
Doc/Data	Η	Date	Step	Qty_	<del> </del> `	or trott comornance	1	iici ciig		- pro-					
Equip/Tooling	H		•				1								
Operator			ŀ									ļ			
Material		!	ļ						Í			<u> </u>			
Setup		,	ļ												ļ
Other								I							1
Process	$\Box$			l	[										
Supplier			ì				1								:
Training			1					;							
Unapproved															<u> </u>
						F	AUI	LT CATE	GORY						
Landi	ng (	Gear				General		-		. ,		٦			1
	L	Bending			<u> </u> _	Bend		Grain				Ovalized		L.	Pressure/Forced
Ì		Centre N	ot Conce	ntric to	O/S	BOM/Route	_	Hardwa	re		_	Over/Under	tolerance	<u>_</u>	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	<u> </u>	Inspecti	ion Incomplete			Part Incorred		L	Weld
		Crushed/	Crimped			Burrs		4	ions Incomplete/l	Unclear	_	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte				Part Moved			
ĺ	L	Heat Trea	et .			Countersink	L	Mislabe	iled			Positioned V	-	_	1
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	t			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Picklist Print** 

August-29-13 1:38:46 PM

Work Order ID:

106393

Parent Item:

D4097-041

Parent Item Name:

ARMREST ASSY

Start Date: 8/29/13

Required Date: 8/29/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

1PP Rev:A as per ECN10-573 DD 10.05.18 verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3696-041 Arm Assembly		Manufactured	No		·	100	Each	5.0000	1	2	M_	N. 1.	3-09
				<u>Location</u>		Loc Oty	Lo	c Code			l		
				ST271	567	5							
				9240		1				X 26	27		
D4098-041 Armrest Cushion Assembly		Manufactured	No	<b></b>		100	Each	2.0000	1 /	X 10.35		'.AQ	· · · · · ·
				Location		Loc Qty	<u>Lo</u>	oc Code			1		
1				ST188	77	2				ĺχ			, ,
D4099-1 Bracket		Manufactured	No	723	<del>, , , _ ,</del>	100	Each	0.0000	1	2	2/	83 p	9/05
, Diacket							R/01	6117	7(2)				1

												DQA:	Da	te.	
NCR: Y	'es /	No				WORK ORDER NON-O	100	NFORM	MANCE / UPE	DATE		QA Closed:	 Da	ite:	
Work Orde	or.				· · · · · · · · · · · · · · · · · · ·	DISPOSITION			_	AGAINST D	Εſ	PARTMENT/	PROCESS		
Part N	 lo		Rework Scrap Use-as-is Work Order Update  Description of work order update						Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	_	Engineering Quality Other
Root			_		Descri	ption of work order update	Ī	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	╛	Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														-	
			_			<del></del>	AUI	T CATE	GORY		_				
Landir					<b>_</b>	General		1		_	_	l			la 15
		ending				Bend	_	Grain		<u> </u>	_	Ovalized		<u> </u>	Pressure/Forced
	_		ot Conce	ntric to	o/s  _	BOM/Route	-	Hardwa		<u> </u>	-	Over/Under		-	Temperature/Cure
	₩.	acks			<u> </u>	Broken/Damaged	<u> </u>	1	on incomplete		_	Part Incorrec		<u> </u>	Weld
	_		Crimped		<u> </u>	Burrs	<u></u>	1	ions Incomplete/U	Jnclear	$\overline{}$	Part Lost/Mi	ssing		Wrong Stock Pulled
{	l Ici	ıffs				Contamination	1	lMainte	enance	Part Moved					

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

August-29-13 1:38:46 PM

Work Order ID: 106393 Start Date: 8/29/13 D4097-041 Required Date: 8/29/13 Parent Item: Required Qty: 2.00 Start Qty: 2.00 Parent Item Name: ARMREST ASSY MS21042L3 No 100 3 Each 6,893.0000 6 Purchased M.D. 13-09-3 Nut Loc Qty Loc Code Location FP001 3 122141 3 GA 18 122452 18 ST314 489 111668 1 117885 32 119017 55 119075 138 123265 43 6X M126036 220 ST506 1383 123900 912 124291 471 ST510a 5000 M126275 1000 4000 M126333 MS24693-C273 No 100 Each 107.0000 Purchased 10 **SCREW** Location Loc Oty Loc Code ST300 107 122539 6 124365 100 m126254 100 MS24693-C277 No Each 12.0000 Purchased Screw Location Loc Oty Loc Code ST300 12 12 113<u>644</u>

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	<b>VFORN</b>	/ANCE / UP	DATE		•			
		_									_	QA Closed:	D:	ate:	
Work Ord	^ ·					DISPOSITION				AGAINST DI	ΕF	PARTMENT	PROCESS		
WORK OTUI	۲۱.					Rework	1		Skid-tube	Crosstube	٦		Water Je	t	Engineering
Part I	Vo.					Scrap	1		Machining	Small Fab	1	Proc	d. Eng. Coor	-	Quality
						Use-as-is	1		noforming	Finishing	Rec/Store/Packag			;	Other
NCR !	No.					Work Order Update	1		Large Fab	Composite			Supplie	r	
	•										_	· .			····
Root						ption of work order update	1	Initial		ction	1	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	4	Date	Verification	on_	QC Inspector
Doc/Data			ļ					ļ			ı				
Equip/Tooling	L.						1		İ		1				1
Operator											١		İ		
Material	<u>                                     </u>				 						ı				
Setup	Ļ										١				
Other	<u> </u>				•						1				
Process	<u> </u>						Ì				ļ	•			
Supplier	L			İ		·						1			i
Training	L						1		<u> </u>						
Unapproved	<u> </u>		<u> </u>		L		<u> </u>		<u> </u>		_				
			_				AUI	T CATE	SORY		_			_	<u> </u>
Landi	ng (	•			_	General	_	1			_			_	1
		Bending				Bend	<b>├</b>	Grain		_	_	Ovalized		$\vdash$	Pressure/Forced
]	<u> </u>	Centre N	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa		<u> </u>	-	Over/Under		<u> </u>	Temperature/Cure
	$oxed{oxed}$	Cracks			<u> </u>	Broken/Damaged	<u> </u>	4 '	ion Incomplete	_	_	Part Incorrec		$\vdash$	Weld
	<u></u>	Crushed/	Crimped		<u></u>	Burrs		1	ions incomplete/	/Unclear	┙	Part Lost/Mi	ssing		Wrong Stock Pulled
	<u></u>	Cuffs			<u></u>	Contamination	$\vdash$	Mainte		_	-1	Part Moved			
	$\perp$	Heat Trea	at		L	Countersink		Misłabe		<u> </u>	-1	Positioned V	_		7
		Inspectio	n Strip in	Tube		Cut Too Short	Misread					Power Loss/	Surge	1	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Picklist Print** 

August-29-13 1:38:46 PM

Page 3

Work Order ID:

106393

Parent Item:

NASI149D0332J

Washer

D4097-041

Parent Item Name:

ARMREST ASSY

Purchased No

Start Date: 8/29/13

Required Date: 8/29/13

Start Qty: 2.00

Required Qty: 2.00

M.U. 13-09-3

2,220.0000

Location		Loc Oty	Loc Code	
ST293		37		
12:	5268	37		
ST294		2183		
12:	2973	106		
12:	5044	102		
	25807	1975		<i>L</i> ex_

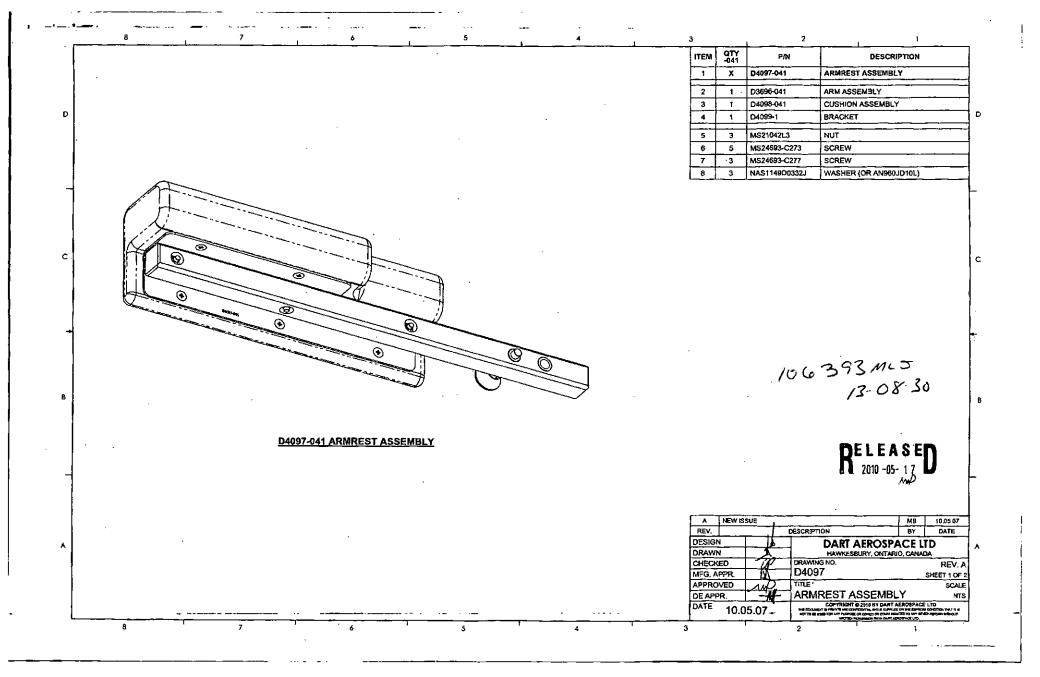
Each

NCR: Y	es / No				WORK ORDER NON-O	CONFO	RMANCE / U	PDATE			
	·								QA Closed:	Date	:
Work Orde	r:	,			DISPOSITION			_	EPARTMENT,		
Part N	o				Rework Scrap Use-as-is	Th	Skid-tube Machining ermoforming	Crosstube Small Fab Finishing	<b>_</b>	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initia		Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng De	scription	Date	Verification	QC Inspector
Doc/Data		ļ	[ [			İ	Ì				
Equip/Tooling		1							1		
Operator		1	1 [								
Material											1
Setup									ì		
Other			1 1								
Process											
Supplier		-	[ ]								
Training [			1 1								
Unapproved									<u> </u>	<u> </u>	
	_				F	AULT CA	TEGORY				
Landir	ng Gear				General			_	_	_	<del></del> 1
	Bending				Bend	Grai	n	L	Ovalized		Pressure/Forced
[	Centre N	ot Conce	ntric to C	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	insp	ection Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instr	uctions Incomplet	e/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
Ī	Cuffs			<u> </u>	Contamination	Mai	ntenance		Part Moved		_
Ī	Heat Trea	•t			Countersink	Misl	abeled		Positioned V	Vrong	_
1	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead	Γ	Power Loss/	Surge	Other
	Ripples in				Drill Holes	Offse	et	_	<del></del>		
	Torque W	/aves in (	extrusion		Drawing	Out	of Calibration				
İ	Turning S	equence			Finish	Out	of Sequence				
	Wave/Tw				Folio	<del></del>	ide Dimensions				

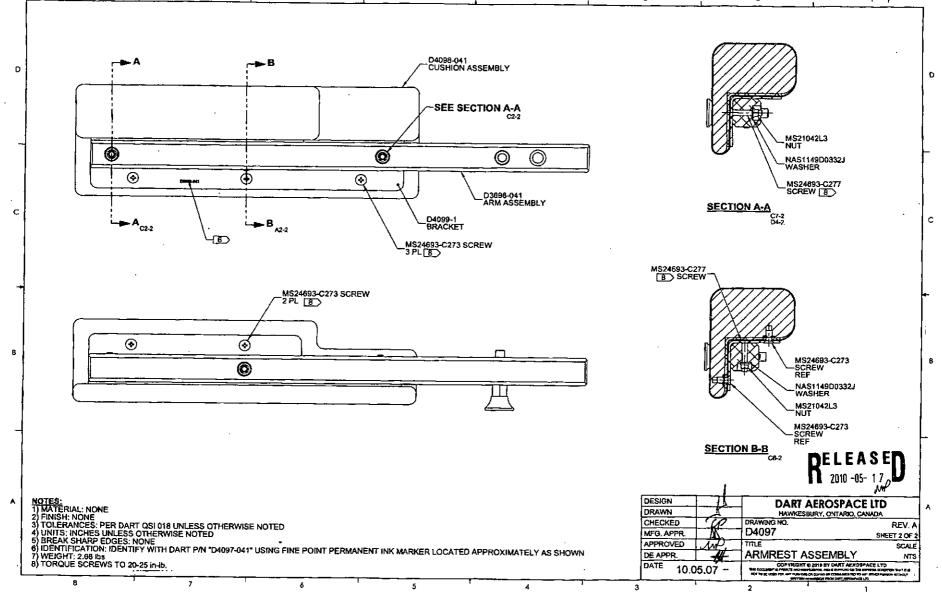
Date: \_\_\_\_\_

DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



·		
· · · · · · · · · · · · · · · · · · ·		



		•	
• • •			

\_\_\_\_\_